












Date: Tuesday, 1/15/2008 9:49:54 AM
User: Kim Johnston

Process Sheet

split
SS 08/03/04 *4* *23*

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GHW MOD KIT
Job Number : 36775	
Estimate Number : 11182	
P.O. Number :	Part Number : D350615041
This Issue : 1/15/2008 S.O. No. :	Drawing Number : D350-615
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 35451	Material :
Written By :	Due Date : 1/22/2008 Qty: 100 Um: Each
Checked & Approved By : <i>08 01 15</i>	
Comment : Est Rev:K Removed Manufacturing : 05-12-05 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	DC DOCUMENT CONTROL
	  <i>RS 08.01.21</i> <i>100</i>
Comment: DOCUMENT CONTROL Photocopy bluefile and type labels (2 GHW Kits per box) as per PPP D350-615-041 CHG003 <i>08/02/06</i>	
2.0	36775A "T" HANDLE ASSEMBLY
	 
Comment: Sub-Component "T" HANDLE ASSEMBLY D2282-041 B <i>36775A</i> <i>100</i> <i>SS 08/02/06</i> <i>100</i>	
3.0	36775B SADDLE ASSEMBLY
	 
Comment: Sub-Component SADDLE ASSEMBLY D2282-043 B <i>35451B</i> <i>42</i> <i>SS 08/02/06</i> <i>42</i>	
4.0	D30153 Lock Nut
	 
Comment: Qty.: 3.0000 Each(s)/Unit Total : 300.0000 Each(s) <i>(126)</i> Pick: Qty Part Number Description Batch 3 D3015-3 5/16 Locknut <i>B 36794</i> <i>ml</i>	
5.0	D30155 SS Nylock Nut 7/16
	 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) <i>(42)</i> Pick: Qty Part Number Description Batch 1 D3015-5 7/16 Locknut <i>B 35101</i> <i>ml</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/15/2008 9:49:54 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MOD KIT

Job Number: 36775

Part Number: D350615041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

51618015C

SS Bolt 5/16-18 1.5" L



Comment: Qty.: 3.0000 Each(s)/Unit Total: ~~300.0000~~ Each(s) (126)

Pick:

Qty Part Number Description Batch

3 5/16-18-015C 5/16 Bolt 1.5 Long M106869

ml

7.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 12.0000 Each(s)/Unit Total: ~~1200.0000~~ Each(s) (504)

Pick:

Qty Part Number Description Batch

12 5/16WC 5/16 Flat Washer M106737

ml

8.0

71614050C

SS Bolt 7/16 5" Long



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~100.0000~~ Each(s) (42)

Pick:

Qty Part Number Description Batch

1 7/16-14-050C 7/16 Bolt 5.0 Long M106881 M106861

ml

9.0

716WC

SS Flat Washer 7/16



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~200.0000~~ Each(s)

Pick:

Qty Part Number Description Batch

2 7/16wc 7/16 Washer M106162 x84

1 D2282-041(Ref) "T" Handle Assembly B36775A x42

1 D2282-043 (Ref) Saddle Assembly B35451B x42

ml

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D2282-041 with D2282-043 as per Dwg D350-615 Only engage one thread on three 5/16-18-015C

bolts

x42

ml 08/03/06

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/03/06 (42)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/03/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/15/2008 9:49:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MOD KIT

Job Number: 36775

Part Number: D350615041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/03/06 (42)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-615-041

Location:

PPP Rev:

Rev E

AS 08/03/06

(42)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/03/07

(42)

Job Completion



AS 2008/3/07

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED DIBY	APPROVED BW	DRAWING NO. D350-615	REV. 8 SHEET 1 OF 2
DATE 97.10.21		TITLE GROUND HANDLING WHEEL MOD.	SCALE NTS
A	95.03.23	NEW ISSUE	
B	97.10.21	CHANGE NUMBERING SCHEME	

-041	Part No.	Description
X	D350-615-041	Ground Handling Wheel Mod.
1	D2282-041	"T" ASSEMBLY
1	D2282-043	SADDLE ASSEMBLY
3	5/16-18-015C	5/16 BOLT 1.5 LONG
3	5/16-18NC	5/16 LOCKNUT (D3015-3)
12	5/16WC	5/16 WASHER
1	7/16-14-050C	7/16 BOLT 5.0 LONG
1	7/16-14NC	7/16 LOCKNUT (D3015-5)
2	7/16WC	7/16 WASHER

THESE INSTRUCTIONS ARE TO BE USED IN CONJUNCTION WITH
THE AIRCRAFT MAINTENANCE AND OVERHAUL INSTRUCTION MANUAL
AC43.13.1A & 2A ACCEPTABLE METHODS, TECHNIQUES, AND PRACTICES

INSTALLATION:

1. Remove existing ground handling wheel pump saddle.
2. Replace saddle with D350-615-041.
3. Torque 5/16 bolts to bottom, then back-off half turn to allow easy rotation without excessive play.

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36775

DART

DESIGN	KE	DRAWN BY	KE	DART, AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
CHECKED	DM	APPROVED	KE	DRAWING NO. D350-615	SHEET 2 OF 2
DATE	97.10.21	TITLE	GROUND HANDLING WHEEL MOD.	SCALE	NTS

D2282-041 "T" ASSEMBLY

7/16-14-050C BOLT (1)
7/16-14NC LOCK NUT (1)
7/16WC WASHER (2)

5/16WC WASHER (REF)

EXISTING PUMP BODY

D2282-043 SADDLE ASSEMBLY

5/16-18-015C BOLT (1)
5/16-18NC LOCK NUT (1)
5/16WC WASHER (4)
(3 PLACES)

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WITHOUT NOTICE
WORK ORDER
NO. 36775

4

Date: Tuesday, 1/15/2008 9:49:56 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : "T" HANDLE ASSEMBLY
 Job Number : 36775A
 Estimate Number : 11179
 P.O. Number :
 This Issue : 1/15/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2282041
 First Issue : 1/1 Type : SMALL/MED FAB Drawing Number : D2282 REV E
 Previous Run : 35451A Material :
 Written By : Due Date : 1/22/2008 Qty: 100 Um: Each
 Checked & Approved By : 08 01/15
 Comment : Est Rev: A Removed from 9 Digit 05-12-02 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D22823 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2282-3

Handle tube

B35472 ~~784~~

FC 08/02/20

(100)

2.0 D22825 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2282-5

Handle tube

B36774 x87
B35473 x13

FC 08/02/20

(100)

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-041 'T' Handle Assembly

Grind chamfers and ensure full penetration.

A/R ER316L SS

Filling Rod

n107051

Dwg Rev: E

FC 08/02/20

(100)

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

FD 08-02-20

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2282-041 PAR #: N/A Fault Category: Prod/Fab. Pass ^{large} NCR: Yes No DQA: D Date: 08/02/26
 QA: N/C Closed: H Date: 08/02/26

NCR: <u>36775A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08-02-20</u>	<u>4</u>	<u>too much under cut. on qty of 4</u>	<u>[Signature]</u>	<u>scrape and replace 4</u> <u>D2282-3 B35172 x 4</u> <u>D2282-5 B36779 x 4</u>	<u>[Signature]</u> <u>08/02/20</u>	<u>PD</u> <u>08-02-20</u>	<u>[Signature]</u>	<u>[Signature]</u>

NOTE: Date & initial all entries

Date: Tuesday, 1/15/2008 9:49:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: "T" HANDLE ASSEMBLY

Job Number: 36775A

Part Number: D2282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

CP 08/02/26 (100)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/02/26 (100)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

SB 08/02/26 100

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 08/02/26 (100)

Job Completion



u 08.02.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

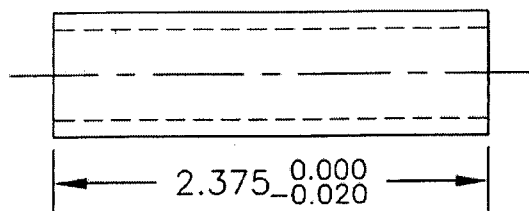
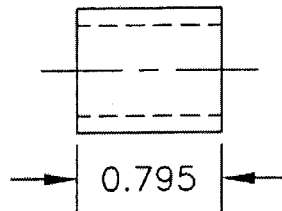
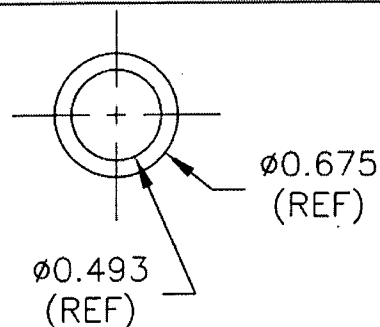
NOTE: Date & initial all entries

DART

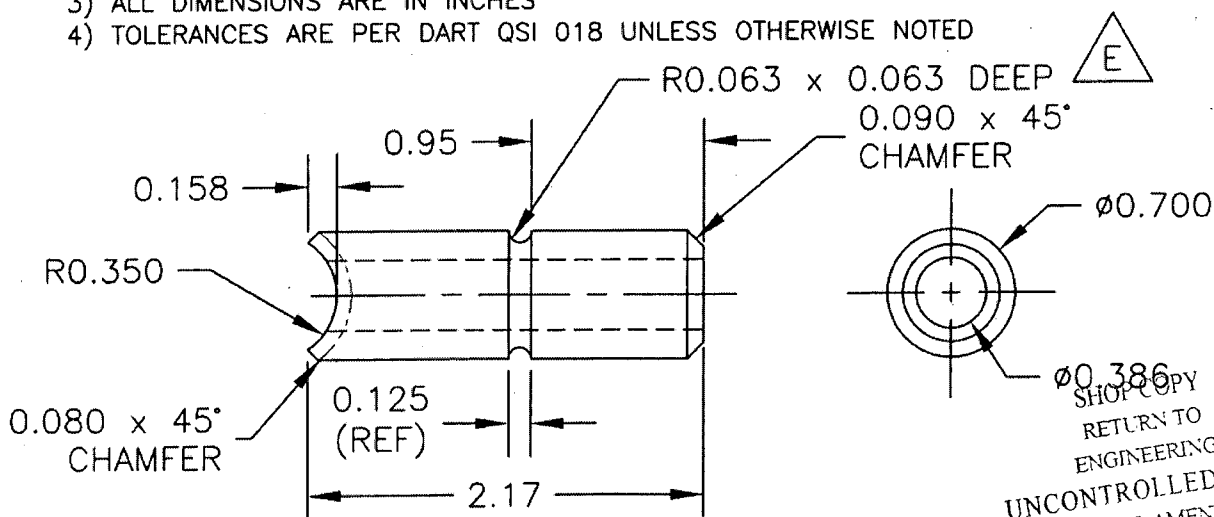
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

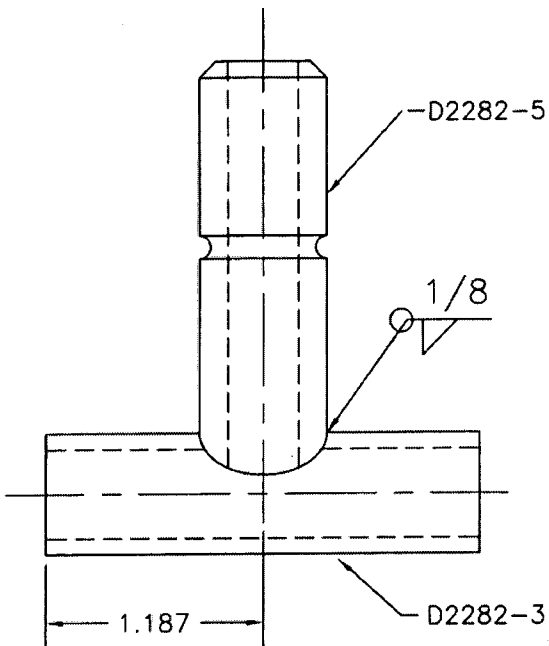
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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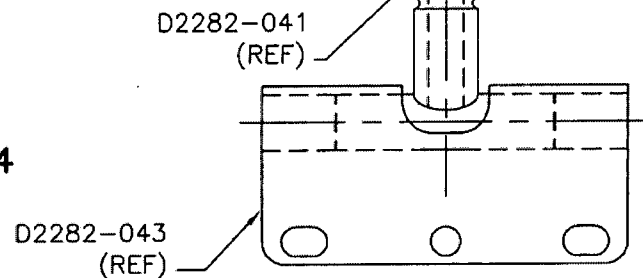
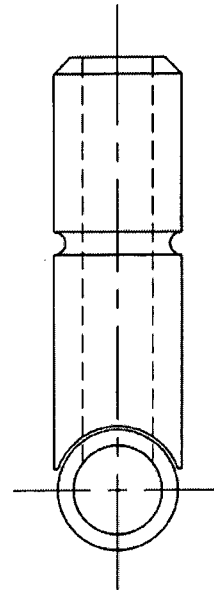
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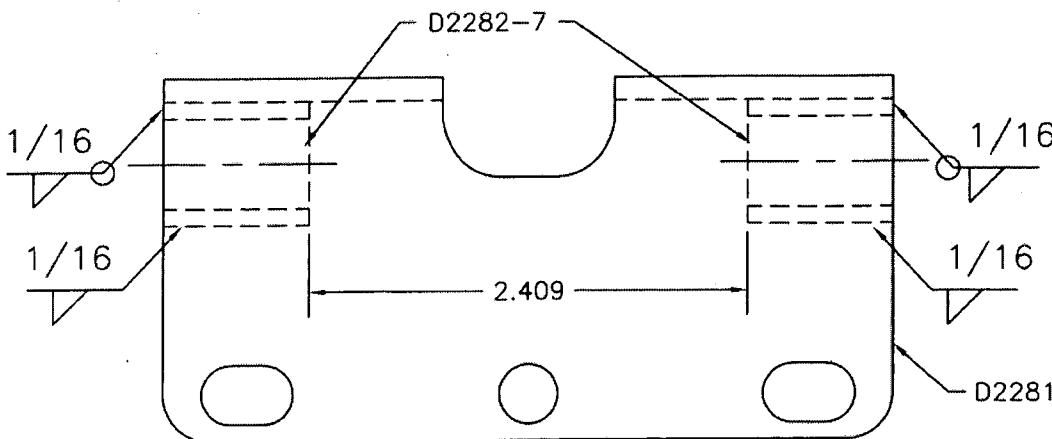
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CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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